

Work Order ID 85918

85918

Page 1

June-18-12 2:32:26 PM

Item ID: D4617-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp Assembly

Stop *NS2*

Start Date: 18/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4617

A

100 Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

4 0 FF 13-01-21

110

0.00

110

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

4 0 FF 13-01-21

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

15 13.121

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

5/1/15

0.00

Packaging

13/11/22 (4)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13/01/22

13-01-22

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Picklist Print

June-18-12 2:32:30 PM

Page 1

Work Order ID: 85918

85918

Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.04.13 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No			100	Each	244.0000	3	12			
AN4-14A									**			FF	13-01-21
Bolt													

Location	Loc Qty	Loc Code
357	121200	100
	121349	100
ST357		144
	120187	13
	120769	1
	121068	17
	121444	100
	121708	13

D4617-5		Manufactured	No			100	Each	4.0000	1	4			
D4617-5									**			FF	13-01-21
Clamp Body													

Location	Loc Qty	Loc Code
ST116	94731	4
	84120	4

D4617-7		Manufactured	No			100	Each	4.0000	1	4			
D4617-7									**			FF	13-01-21
Clamp Half													

Location	Loc Qty	Loc Code
ST116	94522	4
	84121	4

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Picklist Print

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Page 2

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Parent Item: D4617-045

D4617-045

Parent Item Name: Clamp Assembly

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

MS21044N4

Purchased

No

100

Each

64.0000

3

12

MS21044N4

Nut

**

FF 13-01-21

Location

Loc Qty

Loc Code

GA

64

121464

64

12

MS22034-4

Purchased

No

100

Each

16.0000

1

4

MS22034-4

FOOT

**

FF 13-01-21

Location

Loc Qty

Loc Code

ST301

7

121972

7

3

ST304

9

121662

9

1

NAS1149C0463R

Purchased

No

100

Each

825.0000

3

12

NAS1149C0463R

Washer

**

FF 13-01-21

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

824

117735

17

119097

807

12+8 = 20

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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP

D4617-045
CLAMP ASSEMBLY
4 PL

D4618-041
CLAMP ASSY COVER
4 PL
(SHOWN REMOVED THIS LOCATION)

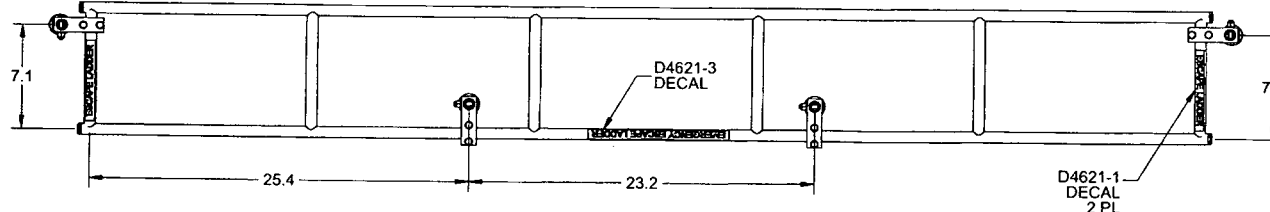
D4617-043
LADDER WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85918 MLJ

12/06/18

D4625-1
TUBE CAP
4 PL

(CLAMP ASSY COVERS REMOVED FOR CLARITY)



D4617-041 EMERGENCY ESCAPE LADDER

B	75.4-75.5 WAS 75.7 (C4-2) WASHER WAS NAS1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-5)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP		
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.05.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4617** REV. B
SHEET 1 OF 5
TITLE **EMERGENCY ESCAPE LADDER** SCALE NTS

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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
 - 7) WEIGHT: 6.48 lbs

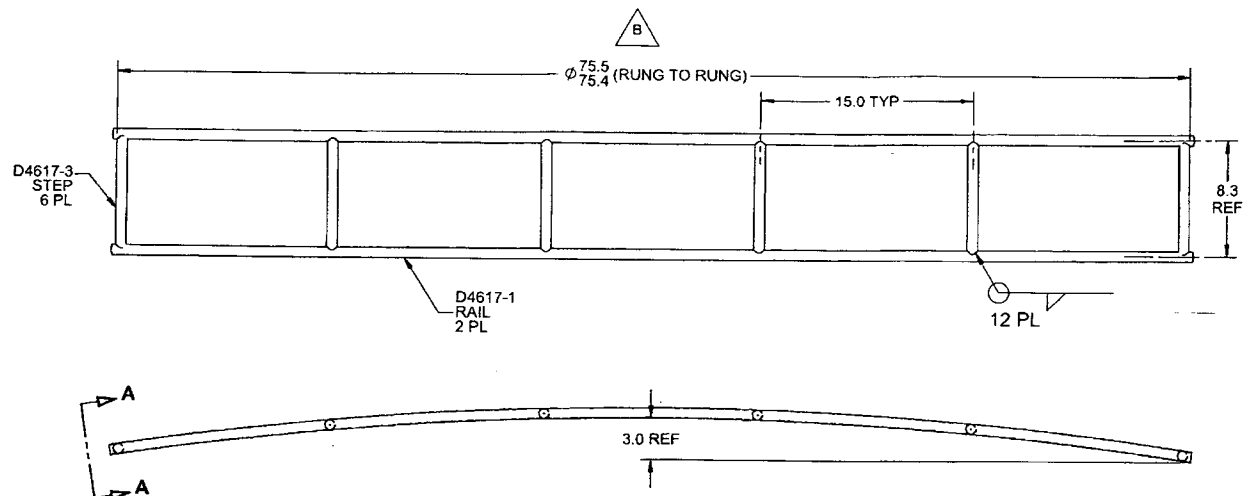
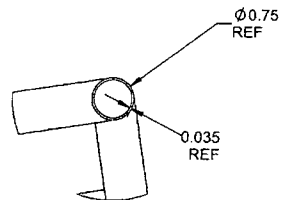
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4617-043 LADDER WELDMENT

RELEASED
2012-05-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO. D4617	REV. B
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

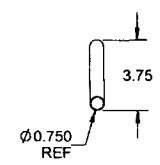
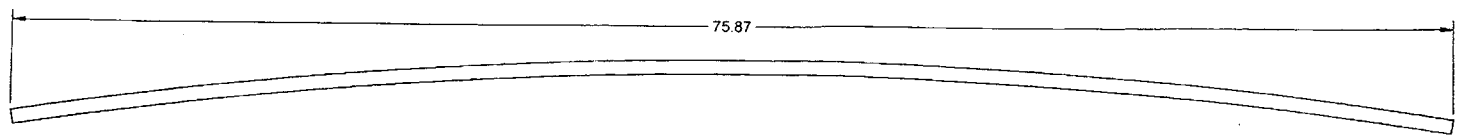
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

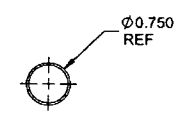
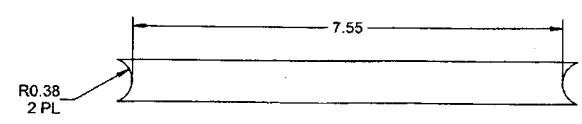
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NOTE: Date & initial all entries

05918



D4617-1 RAIL



D4617-3 STEP

RELEASED
2012-05-17

- NOTES:**
- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI044 6.6
 - 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. B
MFG. APPR.	RP	D4617	SHEET 3 OF 5
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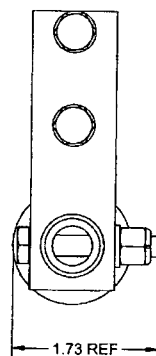
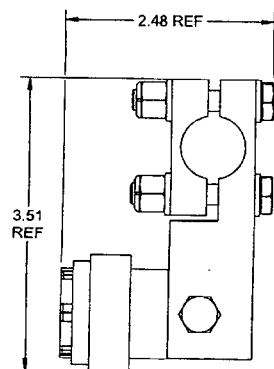
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

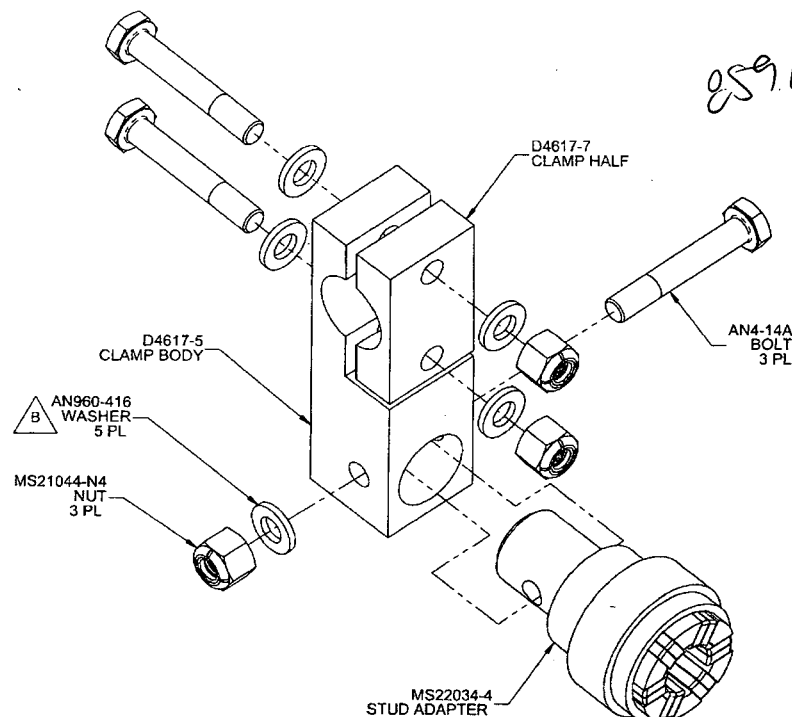
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ITEM	QTY	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	5	AN960-416	WASHER
5	3	MS21044-N4	NUT
6	1	MS22034-4	STUD ADAPTER







D4617-045 CLAMP ASSY



RELEASED
2012-05-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 0.5 lbs

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MFG. APPR.		D4617	SHEET 4 OF 5
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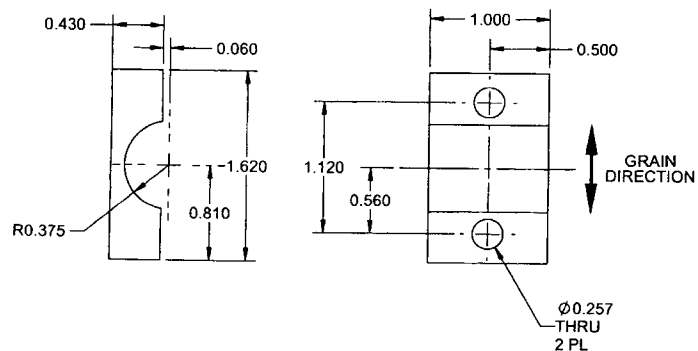
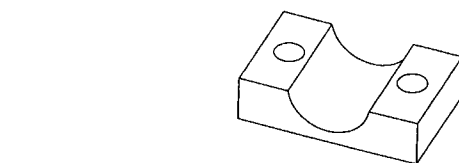
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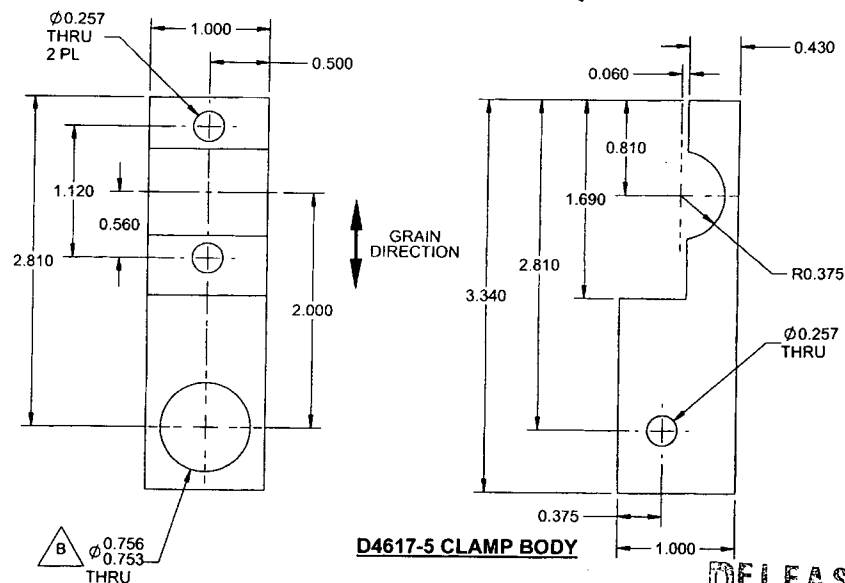
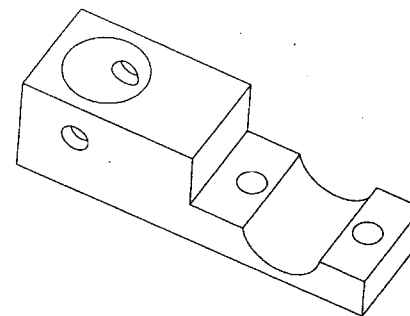
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D4617-7 CLAMP HALF



D4617-5 CLAMP BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06
D4617-7: EAGLE P/N 212-110-07

RELEASED
2012-05-17

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